



Dart Aerospace Ltd.
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D3488-4

Job Sheet 186363



Part No: D3488-4

Job Qty: 10 ea

Part Name: Blade Fitting, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: 11/19/18

Created By: Jesse White

Type: SOLD

Description:

Note: DSK101 REV.D / D3488 REV.C IPP REV:A 18.11.09 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/19/18	11/19/18	0.00	0.00	Start Up Machining-2		
100	Doosan	10 pcs	11/19/18	11/19/18	0.00	8.79	Doosan		
110	QC	10 pcs	11/19/18	11/19/18	0.00	0.00	QC2 Machining-2		
120	CNC Vertical Machining	10 pcs	11/19/18	11/19/18	0.11	6.86	HAAS1-3		
130	QC	10 pcs	11/19/18	11/19/18	0.00	0.00	QC2 Machining-2		
140	QC	10 pcs	11/19/18	11/19/18	0.00	0.00	QC8 Machining-2		
150	HandFinish	10 pcs	11/19/18	11/19/18	0.00	0.30	HandFinish1		
160	Powdercoat	10 pcs	11/19/18	11/19/18	0.00	0.35	Powdercoat1		
170	QC	10 pcs	11/19/18	11/19/18	0.00	0.00	QC3		
200	Packaging	10 pcs	11/19/18	11/19/18	0.00	0.00	Packaging3-1	FP-001	
210	QC21-SA	10 Ea	11/19/18	11/19/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FC492

Descriptions: 120 - 1-Machine as per Folio FA627 & Dwg D3488

160 - START TIME: 1:00 OVEN TEMPERATURE: 320° FINISH TIME: 1:50

200 - LOCATION : FP001

MB8951

21 DEC 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003	Round Billet, Aluminum	10 Ea (1 ea)	90-Start up Operation	5093830 K10

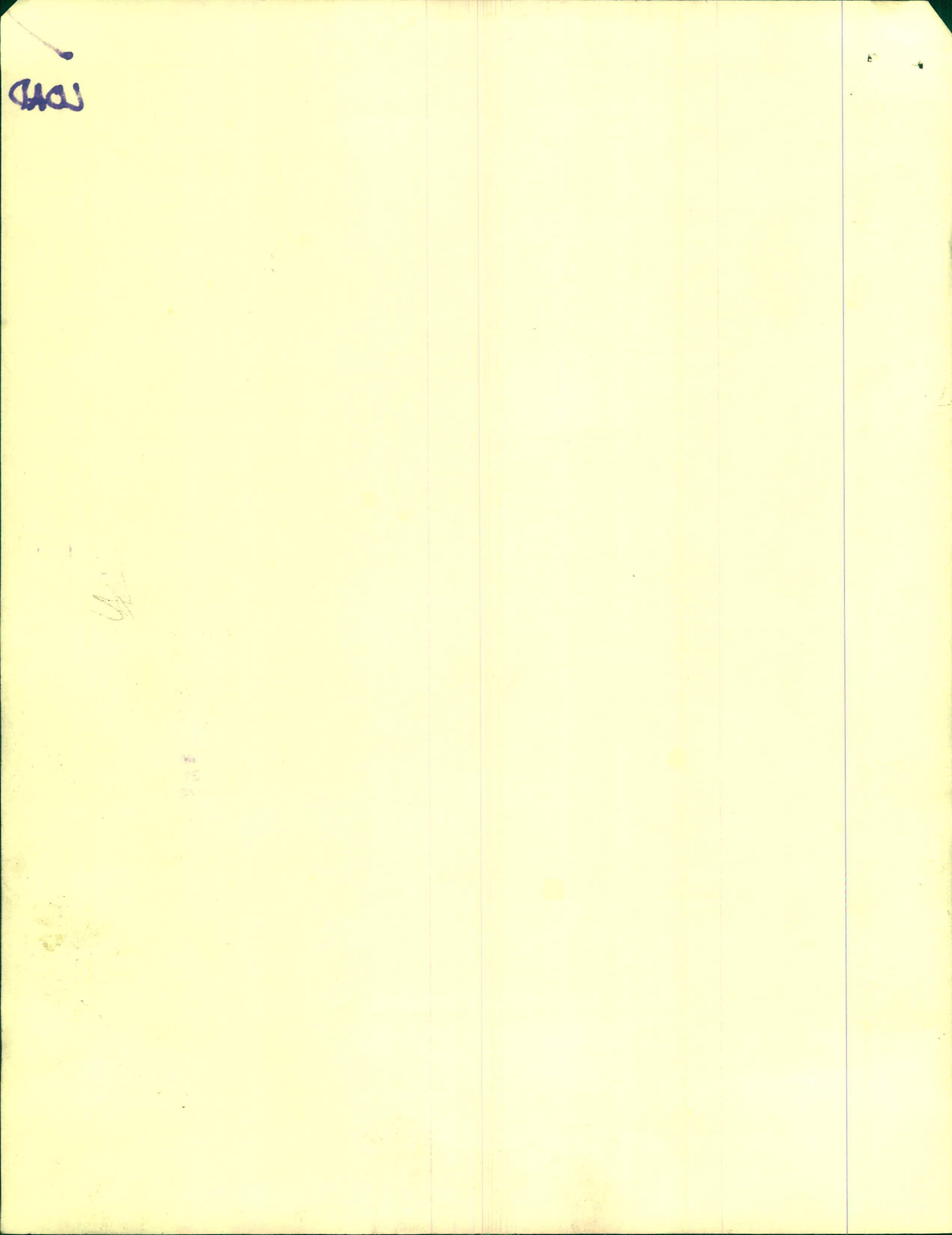
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6103-003	10	43	0

Part Specifications

Specifications could not be found.

Plex 11/14/18 2:12 PM dart.white.jesse



100

DART AEROSPACE LTD		Work Order: 180363
Description: Blade Fitting, RH / Turning Detail for D3488-4		Part Number: D3488-4
Inspection Dwg: D3488 / DSK101 Rev C/D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	REF	2.151			CA/ipo	
Ø2.780	+/-0.005	2.7795				
Ø3.125	+/-0.010	3.123				
Ø3.346	+/-0.010	3.347				
0.125 x 45°	+/-0.010 x +/-0.1°	.124 x 45				
8.000	+0.030/-0.000	8.016				
9.250	+/-0.010	9.2495				
0.188	+/-0.010	.186				
R0.032	+/-0.010	R.132				
R0.062	+/-0.010	R.116				
Ø0.297	+0.005/-0.001					
0.315	+/-0.005	.314				
2.00	+0.010	2.196				TAPER
2.620	+/-0.010	2.62				
Ø0.484	+0.005/-0.001	.486				
1.180	+/-0.010	1.179				
3.150	+/-0.010	3.149				
3.070	+/-0.010	3.068				
R0.063	+/-0.010	R.116				

186363

DART AEROSPACE LTD		Work Order: 185576
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2		Part Number: D3488-24
Inspection Dwg: D3488 / DSK101 Rev: B D		Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	0.508	✓		G.P.	
0.750	+/-0.010	0.750	✓		Vern.	
1.500	+/-0.010	1.500	✓		Vern.	
11.18	+/-0.030	11.176	✓		H.G.	
R0.062	+/-0.010	0.062	✓		R.G.	
0.125	+/-0.010	0.124	✓		Vern.	
0.590	+/-0.010					
0.793	+/-0.010	0.795	✓		Vern.	
1.351	+/-0.010	1.356	✓		H.G.	
1.317	+/-0.010	1.3175	✓		Vern.	
1.802	+/-0.010	1.800	✓		H.G.	
0.715	±0.010	0.711	✓		H.G.	

Measured by: <i>18-12-6 DTP</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: <i>18/11/16</i>	Date: <i>18/12/16</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-042	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

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Container No: S128529



Part: D3488-4

Job No: 186363

Serial No/Batch: S128529

Revision: D/C

Inspector:

Exp Date:

Instructions:

Date: 11/16/18